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RB T103317-101
Job Sheet 201314



DAS
21
9-89

Part No: RB T103317-101

Job Qty: 2 pcs

4 MLL

Part Name: Bender Assembly Trim Tab Main Rotor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T103317-101 Rev B IPP Rev A 18.02.06 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	11/29/19		0.00	2.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	2 pcs	11/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	2 pcs	11/29/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S220718



Part: RB T103317-101

Job No: 201314

Serial No/Batch: S220718

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 10/08/19

DAS
40
9-89

OCT 08 2019

Plex 10/1/19 8:01 AM Dart.lajeunesse.marie

				Packaging 3 - 5 - B4B	DAS				
				Packaging 3 - 6 - B4B	28				
				Packaging 3 - 7 - B4B	9-89				
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - FG	2 pcs	11/29/19	0.00 0.00	QC 21 - FG - 21	DAS
								QC 21 - FG - 70	21
								QC 21 - SA - 53	9-89

OCT 11 2019

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Part Op 110 - (Small Fab) 1-Assemble as per DWG. 2-Applly scotch weld and press fit bolts into -1 as per DWG. note9.
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-7A	Bolt	16 Ea (4 ea)	110-Small Fab - 1	15F 5193820 1X 5107746
MS35426-27	Wing Nut	16 Ea (4 ea)	110-Small Fab - 1	1X 5044190 5X 5092508
NAS1149F0432P	Washer (AN960-416L)	16 Ea (4 ea)	110-Small Fab - 1	3714714
RB T103317-103	Handle	4 2 pcs (1 ea)	110-Small Fab - 1	5196520
RB T103317-105	Plate	4 2 pcs (1 ea)	110-Small Fab - 1	5196522

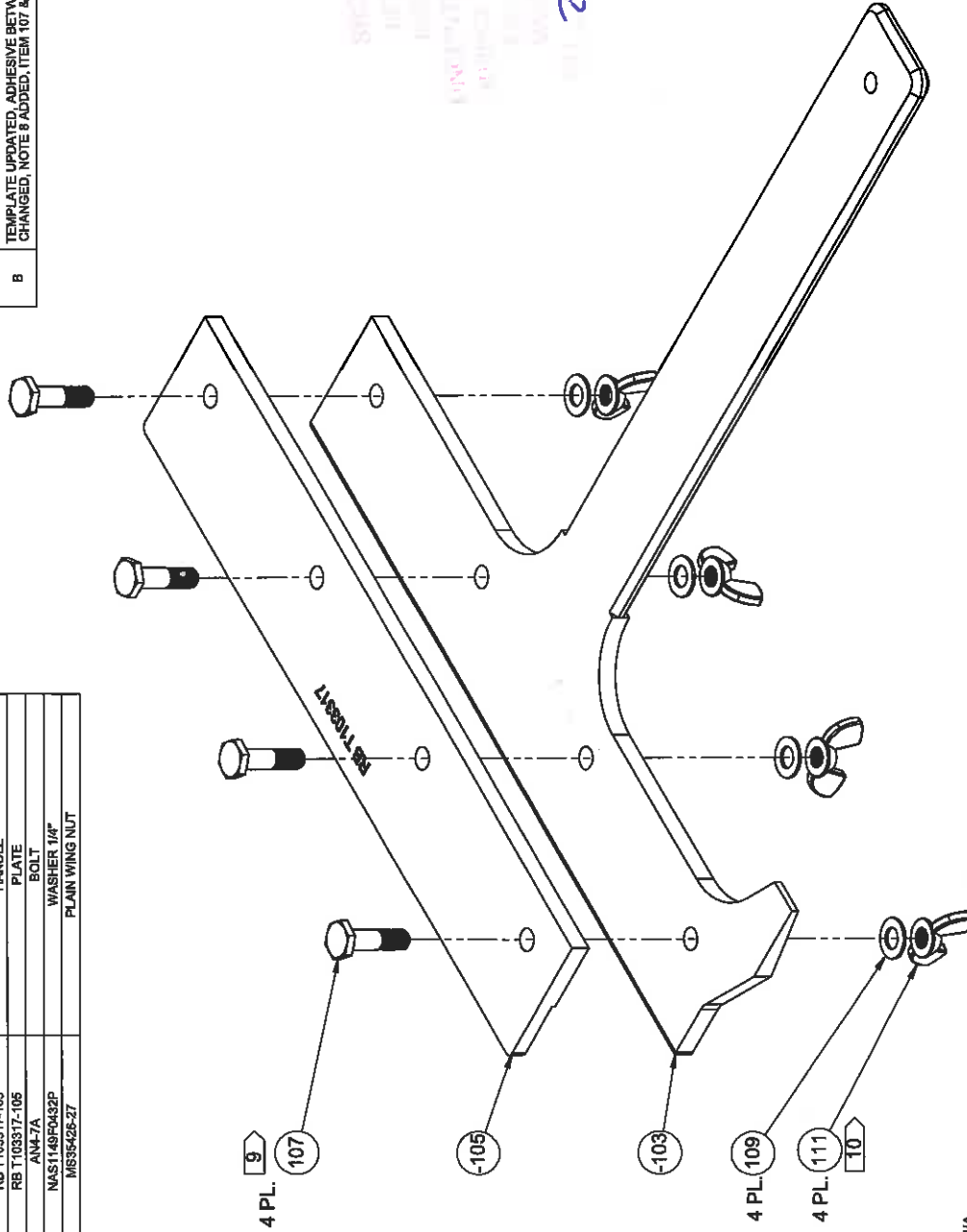
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN4-7A	8	53	0
	MS35426-27	8	121	0
	NAS1149F0432P	8	819	0
	RB T103317-103	2	4	0
	RB T103317-105	2	4	0

Part Specifications

Specifications could not be found.

ITEM #	QTY.	PART #	TITLE	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-103	1	RB T103317-103	HANDLE	A	RELEASE FOR PRODUCTION	-	01-18-15	-	-
-105	1	RB T103317-105	PLATE	B	TEMPLATE UPDATED, ADHESIVE BETWEEN 107 & -105 CHANGED, NOTE 8 ADDED, ITEM 107 & 108 CHANGED	17-769	17.12.18	VM	ML
107	4	AN4-7A	BOLT						
109	4	NAS1149F0432P	WASHER 1/4"						
111	4	MS35426-27	PLAIN WING NUT						



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) HEAT TREAT: N/A
 - 4) SPEC: N/A
 - 5) TOLERANCES: PER QSI 018 UNLESS OTHERWISE NOTED
 - 6) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 7) BREAK ALL SHARP EDGES: N/A
 - 8) IDENTIFICATION: N/A
 - 9) APPLY SCOTCH WELD DP480 EPOXY UNDER THE BOLT HEAD AND PRESS THE BOLT INTO ITEM -105. ALLOW TO CURE PER MANUFACTURER'S INSTRUCTIONS.
 - 10) HAND TIGHTEN ONLY

RB T103317-101 BENDER ASSY - TRIM TAB MAIN ROTOR BLADE

PART BENDER ASSY - TRIM TAB MAIN ROTOR BLADE	
PART NO.	RB T103317-101
REV.	B
RELEASE FOR PRODUCTION BY: [Signature] INTERPRET FOR ASSEMBLY: [Signature] INTERPRET FOR ASSEMBLY: [Signature]	
DESIGNED BY:	VM 11/27/2017
DRAWN BY:	VM 01/03/2018
CHECKED BY:	VM 01/03/2018
APPROVED BY:	UD 01/05/2018
DATE	01/05/2018
SCALE	1" = 1"
FRACCTIONS	1/8"
ANGLES	1/2"
BOUGIES	1/2"
SHEET 1 OF 2	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐
Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____